

Date: Tuesday, 04/03/2008 11:17:00 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PANEL-350 UPPER BULKHEAD		
Job Number	: 37664			Part Number	: D36553		
Estimate Number	: 13100			Drawing Number	: D36553-PROTOTYPE		
P.O. Number	:			Project Number	: 00204		
This Issue	: 04/03/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: THERMOFORMING	Due Date	: 11/03/2008 Qty: 1 Um: Each		
Previous Run	:						
Written By	:						
Checked & Approved By	: <u>V</u>						
Comment	: Est. Rev. A 07/12/13 DL						

Additional Product

WLO REPLACED

~~PROTOTYPE~~
PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
0.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
Comment: Qty.: 23.0000 sf(s)/Unit Total : 23.0000 sf(s) GE PLASTICS LEXAN SHEET M105494		
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING 1) Cut Blanks DL 08/03/04		
2.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE Thermoform as per Dwg. D3655-3 and Folio FTA 017 using tool DT8985 Dwg. Rev. <u>A</u> DL 08/03/04 Folio Rev. <u>A</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE DL 08/03/04		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 04/03/2008 11:17:00 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 UPPER BULKHEAD

Job Number: 37664

Part Number: D36553

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

MF 08/03/04

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

MF 08/03/04

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf

08-03-28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 04/03/2008 11:17:04 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PANEL-350 FWD CANOPY		
Job Number	: 37666			Part Number	: D36563		
Estimate Number	: 13099			Drawing Number	: D36563-PROTOTYPE		
P.O. Number	:			Project Number	: 00204		
This Issue	: 04/03/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: THERMOFORMING	Due Date	: 11/03/2008	Qty:	1 Um: Each
Previous Run	: 37112						
Written By	:						
Checked & Approved By	:						
Comment	: Est. Rev. A 07/12/13 DL						

Additional Product

W/O REPLACED

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :	
0.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET	
Comment: Qty.: 23.0000 sf(s)/Unit Total : 23.0000 sf(s) GE PLASTICS LEXAN SHEET			
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
Comment: HAND FINISHING THERMOFORMING			
1) Cut Blanks			
2.0	THERMOFORMING	THERMOFORMING MACHINE	
Comment: THERMOFORMING MACHINE			
Thermoform as per Dwg. D3656-3and Folio FTA 016 using tool DT8987			
Dwg. Rev. _____			
Folio Rev. _____			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
Comment: SECOND CHECK			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 04/03/2008 11:17:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 FWD CANOPY

Job Number: 37666

Part Number: D36563

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries